



Dart Aerospace Ltd.
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RBEM632V3021125
Job Sheet 180214



Part No: RBEM632V3021125

Job Qty: 1 ea

Part Name: Extractor



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 7/3/18

Job Tracking No:

Due Date: 10/1/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM632V3021125 Rev. 2 IPP Rev. A 18.06.25 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/1/18	0.00	0.00	Start Up Small Fab-4		MLC
100	Small Fab	1 pcs		10/1/18	0.00	0.20	Small Fab-9		MLC
110	QC	1 pcs		10/1/18	0.00	0.00	QC5		SB
130	Packaging	1 pcs		10/1/18	0.00	0.00	Packaging3-2		SB
140	QC21-FG	1 Ea		10/1/18	0.00	0.00	QC21		21 OCT 17 2018

Part Op 100 - 1-Assemble as per DWG.
Descriptions: 130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
50 91455A140	Flat Washer	1 Ea (1 ea)	90-Start up Operation	3050902
59 92497A450	Hex Nut	1 Ea (1 ea)	90-Start up Operation	3091259
GA RBEM632V3021125-1	Frame	1 Ea (1 ea)	100-Small Fab	3101282
134A RBEM632V3021125-3	Jaw	4 Ea (4 ea)	100-Small Fab	3101822
GA RBEM632V3021125-5	Clevis Pin	4 Ea (4 ea)	100-Small Fab	3111779
134A RBEM632V3021125-7	Bolt	1 Ea (1 ea)	100-Small Fab	3116455
GA RBEM632V3021125-9	Ring	1 Ea (1 ea)	100-Small Fab	3116666

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	91455A140	1	100	0
	92497A450	1	50	0
100-Small Fab	RBEM632V3021125-1	1	8	0
	RBEM632V3021125-3	4	24	0
	RBEM632V3021125-5	4	24	0
	RBEM632V3021125-7	1	10	0
	RBEM632V3021125-9	1	6	0

Part Specifications

Specifications could not be found.



AEROSPACE

Container No: S119004



Part: RBEM632V3021125

Job No: 180214

Serial No/Batch: S119004

Revision: 2

Inspector:

Exp Date:

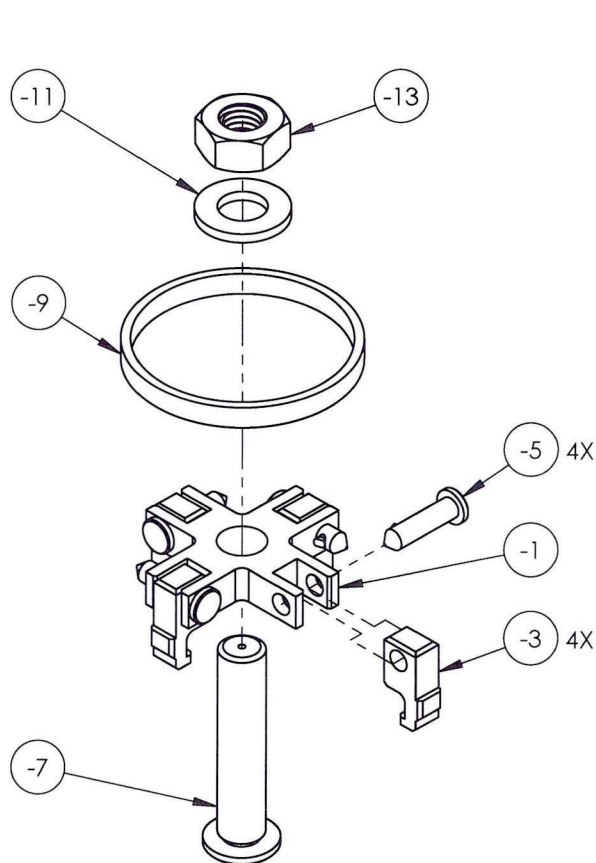
Instructions:

Date: 10/17/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION	8/12/2016	SM	JAG
2	17-0018	CH'D NOTE 2 SHEET 1 WAS PART OF KIT RBEM323U3006103 IS PART OF KIT RBRM632V3021 102. -3 CH'D DIM WAS .08 IS .05, WAS .330 IS .360. -7 ADDED CENTER OK NOTE, CH'D DIM WAS .03 X 45° IS 2X .03 X 45°.	1/25/2017	RJC	



- NOTES:
1. REF. EUROCOPTER T/N: M632V3021 125.
 2. PART OF KIT RBEM632V3021 102.

DART AEROSPACE																	
TITLE EXTRACTOR																	
DWG NO. RBEM632V3021 125	REV 2																
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT TREAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>SPEC</td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td></td> <td>X ± .1 SURFACES = 125/</td> </tr> <tr> <td colspan="2">1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td colspan="2">2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td colspan="2">3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT TREAT	DIMENSIONS ARE IN INCHES	FINISH	.XXX ± .005 FRACTIONS ± 1/8	SPEC	.XX ± .01 ANGLES ± 5°		X ± .1 SURFACES = 125/	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		2. DIMENSIONAL LIMITS APPLY AFTER PLATING		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
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DRAWN BY: MACKOVJAK	USED ON MODEL																
CHECKED: CLOUGH	H175																
OPPS APPR: ANDERSON																	
QA APPR: LINDSAY																	
APPROVED: GILBERT																	
SCALE 2:3	DATE 3/23/2016																
SHEET 1 OF 6																	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	FRAME	4140/4142		2
			-3	4	JAW	4140/4142		3
			-5	4	CLEVIS PIN	S.S.	Ø3/16 X 1/2 USABLE (MCMASTER-CARR #94411A510) MODIFIED	4
			-7	1	BOLT	1018/1020 CR		5
			-9	1	RING	6061		6
		B/O	-11	1	WASHER	STEEL	M10 (MCMASTER-CARR # 91455A140)	1
		B/O	-13	1	NUT	STEEL	M10 X 1.5 (MCMASTER-CARR # 92497A450)	1